

Date: Monday, 5/15/2006 11:12:19 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 27119
Estimate Number : 10937
P.O. Number : N/A Part Number : D29392
This Issue : 5/15/2006 S.O. No. : N/A Drawing Number : D2939 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : 5/15/2006 Type : MACHINED PARTS Drawing Revision : B
Previous Run : 26371 Material : N/A
Written By : See Comment Below Due Date : 5/30/2006 Qty: 8 Um: Each
Checked & Approved By : 06.05.15
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length
Batch No: B 25342

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr

JL 06/07/05

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

En 06/07/24 x8

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JL 06/07/05 8

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/07/24 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 02/07/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:12:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27119

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/25

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25
DC

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AR 06/07/28 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

AR 06/07/28 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/07/28

Job Completion



KJ 06.07.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27119
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.117	.121	.120		
B	0.100	0.140		.120	.115	.114	.120		
C	0.100	0.140		.127	.124	.126	.127		
D	0.210	0.230		.220	.218	.221	.221		
E	1.245	1.255		1.250	1.250	1.251	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.572	1.582		1.577	1.577	1.577	1.576		
J	2.495	2.505		2.500	2.499	2.499	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.237	0.236	0.236		
N	0.100	0.140		.120	.110	.120	.120		
O	0.540	0.560		.549	.550	.550	.551		
P	0.490	0.510		.502	.501	.501	.502		
Q	3.715	3.725		3.719	3.719	3.720	3.719		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.251	.242	.251	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.260	1.260	1.261	1.260		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / En
Date: 06/07/04 / 06/07/14

Audited by: JML
Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF JH	JH

DART AEROSPACE LTD	Work Order: 27119
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

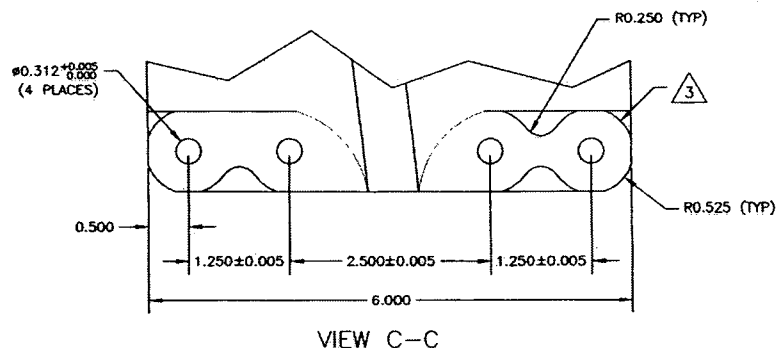
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.120	.120	.121		
B	0.100	0.140		.121	.120	.120	.121		
C	0.100	0.140		.126	.127	.127	.127		
D	0.210	0.230		.220	.223	.220	.222		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.249	1.251	1.249	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.500		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.572	1.582		1.578	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.236	0.236	0.236		
N	0.100	0.140		.121	.122	.121	.121		
O	0.540	0.560		.551	.551	.551	.550		
P	0.490	0.510		.502	.500	.500	.499		
Q	3.715	3.725		3.717	3.720	3.719	3.719		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.252	.254	.252	.251		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.630		
V	1.362	1.372		1.368	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.261	1.262	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL / Ep
Date:	06/07/25 / 06/07/24

Audited by:	Sm
Date:	06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

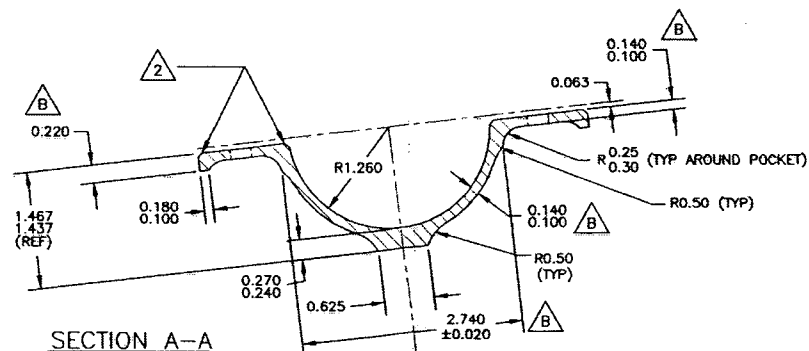
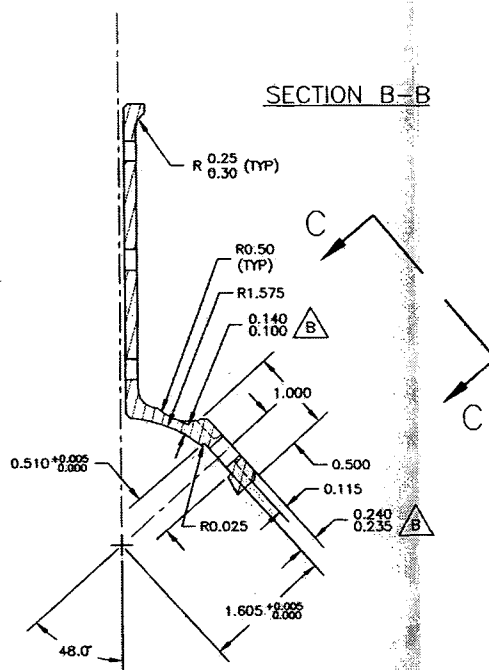


VIEW C-C

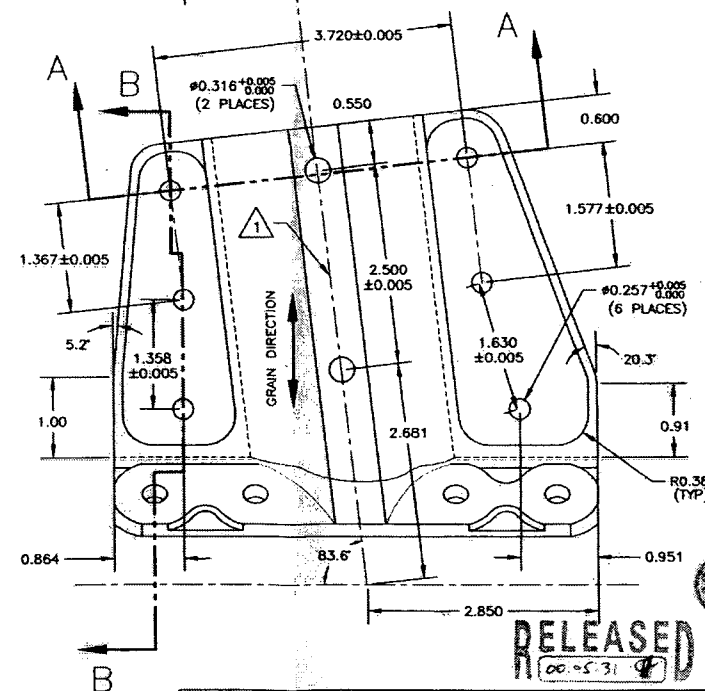
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



SECTION A-A



RELEASED
 00-531

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 DART AEROSPACE USA, INC.

B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO: D2939
DATE: 00.05.29	TITLE: SADDLE INSIDE	REV. B SHEET 1 OF 1 SCALE: 2:3